

Exhibit 3



Code of Federal Regulations

21

Parts 100 to 169

Revised as of April 1, 2005

Food and Drugs

Containing a codification of documents
of general applicability and future effect

As of April 1, 2005

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Office of the Federal Register
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(4) Devices or fixtures, such as water control valves, so designed and constructed to protect against recontamination of clean, sanitized hands.

(5) Readily understandable signs directing employees handling unprotected food, unprotected food-packaging materials, of food-contact surfaces to wash and, where appropriate, sanitize their hands before they start work, after each absence from post of duty, and when their hands may have become soiled or contaminated. These signs may be posted in the processing room(s) and in all other areas where employees may handle such food, materials, or surfaces.

(6) Refuse receptacles that are constructed and maintained in a manner that protects against contamination of food.

(f) *Rubbish and offal disposal.* Rubbish and any offal shall be so conveyed, stored, and disposed of as to minimize the development of odor, minimize the potential for the waste becoming an attractant and harborage or breeding place for pests, and protect against contamination of food, food-contact surfaces, water supplies, and ground surfaces.

Subpart C—Equipment

§ 110.40 Equipment and utensils.

(a) All plant equipment and utensils shall be so designed and of such material and workmanship as to be adequately cleanable, and shall be properly maintained. The design, construction, and use of equipment and utensils shall preclude the adulteration of food with lubricants, fuel, metal fragments, contaminated water, or any other contaminants. All equipment should be so installed and maintained as to facilitate the cleaning of the equipment and of all adjacent spaces. Food-contact surfaces shall be corrosion-resistant when in contact with food. They shall be made of nontoxic materials and designed to withstand the environment of their intended use and the action of food, and, if applicable, cleaning compounds and sanitizing agents. Food-contact surfaces shall be maintained to protect food from being contaminated by any source, including unlawful indirect food additives.

(b) Seams on food-contact surfaces shall be smoothly bonded or maintained so as to minimize accumulation of food particles, dirt, and organic matter and thus minimize the opportunity for growth of microorganisms.

(c) Equipment that is in the manufacturing or food-handling area and that does not come into contact with food shall be so constructed that it can be kept in a clean condition.

(d) Holding, conveying, and manufacturing systems, including gravimetric, pneumatic, closed, and automated systems, shall be of a design and construction that enables them to be maintained in an appropriate sanitary condition.

(e) Each freezer and cold storage compartment used to store and hold food capable of supporting growth of microorganisms shall be fitted with an indicating thermometer, temperature-measuring device, or temperature-recording device so installed as to show the temperature accurately within the compartment, and should be fitted with an automatic control for regulating temperature or with an automatic alarm system to indicate a significant temperature change in a manual operation.

(f) Instruments and controls used for measuring, regulating, or recording temperatures, pH, acidity, water activity, or other conditions that control or prevent the growth of undesirable microorganisms in food shall be accurate and adequately maintained, and adequate in number for their designated uses.

(g) Compressed air or other gases mechanically introduced into food or used to clean food-contact surfaces or equipment shall be treated in such a way that food is not contaminated with unlawful indirect food additives.

Subpart D [Reserved]

Subpart E—Production and Process Controls

§ 110.80 Processes and controls.

All operations in the receiving, inspecting, transporting, segregating, preparing, manufacturing, packaging, and storing of food shall be conducted in accordance with adequate sanitation

principles. All operations shall be so conducted that food is not adulterated. Sanitation of materials and equipment shall be so conducted that the supervision of the sanitization of the premises and equipment shall be sufficient to insure that the product is not contaminated. The product shall be so handled that it is not adulterated. The act shall be so conducted that the contamination of the product is prevented. The product shall be so handled that it is not adulterated. The act shall be so conducted that the contamination of the product is prevented.

(a) *Raw materials.* (1) Raw materials shall be so handled that they are not adulterated. The act shall be so conducted that the contamination of the product is prevented. The product shall be so handled that it is not adulterated. The act shall be so conducted that the contamination of the product is prevented.

(2) Raw materials shall be so handled that they are not adulterated. The act shall be so conducted that the contamination of the product is prevented. The product shall be so handled that it is not adulterated. The act shall be so conducted that the contamination of the product is prevented.

Food-contact surfaces shall be bonded or maintained to minimize accumulation of dirt, and organic materials shall be kept free of opportunity for microorganisms.

Material is in the manufacturing area and is in contact with equipment, it shall be constructed that it can be in good condition.

weighing, and manufacturing including gravimetric, and automated systems shall be designed and constructed so as to be maintained in appropriate sanitary condition.

and cold storage to store and hold product without spoiling growth of microorganisms. All equipment shall be fitted with an automatic temperature or temperature-recording device installed as to show accurately within the range of temperature. It should be fitted with a control for regulation or with an automatic device to indicate a significant change in a manufacturing process.

and controls used for weighing, or recording acidity, water activity, and other factors that control or inhibit the growth of undesirable microorganisms. Food shall be accurately maintained, and equipment shall be used for their design.

or other gases measured into food or used on contact surfaces or equipment in such a way that it is not contaminated with undesirable additives.

[Reserved]

Production and Controls

and controls.

the receiving, inspecting, segregating, storing, packaging, and shipping shall be conducted under adequate sanitation

principles. Appropriate quality control operations shall be employed to ensure that food is suitable for human consumption and that food-packaging materials are safe and suitable. Overall sanitation of the plant shall be under the supervision of one or more competent individuals assigned responsibility for this function. All reasonable precautions shall be taken to ensure that production procedures do not contribute to contamination from any source. Chemical, microbial, or extraneous-material testing procedures shall be used where necessary to identify sanitation failures or possible food contamination. All food that has become contaminated to the extent that it is adulterated within the meaning of the act shall be rejected, or if permissible, treated or processed to eliminate the contamination.

(a) *Raw materials and other ingredients.* (1) Raw materials and other ingredients shall be inspected and segregated or otherwise handled as necessary to ascertain that they are clean and suitable for processing into food and shall be stored under conditions that will protect against contamination and minimize deterioration. Raw materials shall be washed or cleaned as necessary to remove soil or other contamination. Water used for washing, rinsing, or conveying food shall be safe and of adequate sanitary quality. Water may be reused for washing, rinsing, or conveying food if it does not increase the level of contamination of the food. Containers and carriers of raw materials should be inspected on receipt to ensure that their condition has not contributed to the contamination or deterioration of food.

(2) Raw materials and other ingredients shall either not contain levels of microorganisms that may produce food poisoning or other disease in humans, or they shall be pasteurized or otherwise treated during manufacturing operations so that they no longer contain levels that would cause the product to be adulterated within the meaning of the act. Compliance with this requirement may be verified by any effective means, including purchasing raw materials and other ingredients under a supplier's guarantee or certification.

(3) Raw materials and other ingredients susceptible to contamination with aflatoxin or other natural toxins shall comply with current Food and Drug Administration regulations and action levels for poisonous or deleterious substances before these materials or ingredients are incorporated into finished food. Compliance with this requirement may be accomplished by purchasing raw materials and other ingredients under a supplier's guarantee or certification, or may be verified by analyzing these materials and ingredients for aflatoxins and other natural toxins.

(4) Raw materials, other ingredients, and rework susceptible to contamination with pests, undesirable microorganisms, or extraneous material shall comply with applicable Food and Drug Administration regulations and defect action levels for natural or unavoidable defects if a manufacturer wishes to use the materials in manufacturing food. Compliance with this requirement may be verified by any effective means, including purchasing the materials under a supplier's guarantee or certification, or examination of these materials for contamination.

(5) Raw materials, other ingredients, and rework shall be held in bulk, or in containers designed and constructed so as to protect against contamination and shall be held at such temperature and relative humidity and in such a manner as to prevent the food from becoming adulterated within the meaning of the act. Material scheduled for rework shall be identified as such.

(6) Frozen raw materials and other ingredients shall be kept frozen. If thawing is required prior to use, it shall be done in a manner that prevents the raw materials and other ingredients from becoming adulterated within the meaning of the act.

(7) Liquid or dry raw materials and other ingredients received and stored in bulk form shall be held in a manner that protects against contamination.

(b) *Manufacturing operations.* (1) Equipment and utensils and finished food containers shall be maintained in an acceptable condition through appropriate cleaning and sanitizing, as necessary. Insofar as necessary, equipment

shall be taken apart for thorough cleaning.

(2) All food manufacturing, including packaging and storage, shall be conducted under such conditions and controls as are necessary to minimize the potential for the growth of microorganisms, or for the contamination of food. One way to comply with this requirement is careful monitoring of physical factors such as time, temperature, humidity, a_w , pH, pressure, flow rate, and manufacturing operations such as freezing, dehydration, heat processing, acidification, and refrigeration to ensure that mechanical breakdowns, time delays, temperature fluctuations, and other factors do not contribute to the decomposition or contamination of food.

(3) Food that can support the rapid growth of undesirable microorganisms, particularly those of public health significance, shall be held in a manner that prevents the food from becoming adulterated within the meaning of the act. Compliance with this requirement may be accomplished by any effective means, including:

(i) Maintaining refrigerated foods at 45 °F (7.2 °C) or below as appropriate for the particular food involved.

(ii) Maintaining frozen foods in a frozen state.

(iii) Maintaining hot foods at 140 °F (60 °C) or above.

(iv) Heat treating acid or acidified foods to destroy mesophilic microorganisms when those foods are to be held in hermetically sealed containers at ambient temperatures.

(4) Measures such as sterilizing, irradiating, pasteurizing, freezing, refrigerating, controlling pH or controlling a_w that are taken to destroy or prevent the growth of undesirable microorganisms, particularly those of public health significance, shall be adequate under the conditions of manufacture, handling, and distribution to prevent food from being adulterated within the meaning of the act.

(5) Work-in-process shall be handled in a manner that protects against contamination.

(6) Effective measures shall be taken to protect finished food from contamination by raw materials, other ingredients, or refuse. When raw materials,

other ingredients, or refuse are unprotected, they shall not be handled simultaneously in a receiving, loading, or shipping area if that handling could result in contaminated food. Food transported by conveyor shall be protected against contamination as necessary.

(7) Equipment, containers, and utensils used to convey, hold, or store raw materials, work-in-process, rework, or food shall be constructed, handled, and maintained during manufacturing or storage in a manner that protects against contamination.

(8) Effective measures shall be taken to protect against the inclusion of metal or other extraneous material in food. Compliance with this requirement may be accomplished by using sieves, traps, magnets, electronic metal detectors, or other suitable effective means.

(9) Food, raw materials, and other ingredients that are adulterated within the meaning of the act shall be disposed of in a manner that protects against the contamination of other food. If the adulterated food is capable of being reconditioned, it shall be reconditioned using a method that has been proven to be effective or it shall be reexamined and found not to be adulterated within the meaning of the act before being incorporated into other food.

(10) Mechanical manufacturing steps such as washing, peeling, trimming, cutting, sorting and inspecting, mashing, dewatering, cooling, shredding, extruding, drying, whipping, defatting, and forming shall be performed so as to protect food against contamination. Compliance with this requirement may be accomplished by providing adequate physical protection of food from contaminants that may drip, drain, or be drawn into the food. Protection may be provided by adequate cleaning and sanitizing of all food-contact surfaces, and by using time and temperature controls at and between each manufacturing step.

(11) Heat blanching, when required in the preparation of food, should be effected by heating the food to the required temperature, holding it at this temperature for the required time, and then either rapidly cooling the food or

passing it to subsequent processing without delay. Thermal shock and contamination shall be minimized by the use of adequate cleaning. Where the food is washed prior to final processing, it shall be safe and of quality.

(12) Batters, breadings, dressings, and other coatings shall be treated in such a manner that they are protected against contamination with this requirement may be accomplished by any effective means, including one or more of the following:

(i) Using ingredients that are safe and suitable.

(ii) Employing adequate controls where applicable.

(iii) Using adequate temperature controls.

(iv) Providing adequate protection of components that may drip, drain, or be drawn into the food.

(v) Cooling to an appropriate temperature during manufacture.

(vi) Disposing of food at appropriate intervals to prevent growth of microorganisms.

(13) Filling, assembling, and other operations shall be performed in such a way that the food is protected against contamination. Compliance with this requirement may be accomplished by any effective means, including:

(i) Use of a quality control system in which the critical control points are identified and controlled.

(ii) Adequate cleaning of all food-contact surfaces and containers.

(iii) Using materials and packaging that are safe and suitable under the conditions of manufacture.

(iv) Providing protection from contamination borne by the food.

(v) Using sanitizing agents.

(14) Food such as, but not limited to, dry mixes, nuts, intact food, and dehydrate shall be controlled on the control of a_w .

or refuse are unprocessed, receiving, loading, that handling could contaminate food. Food conveyor shall be protected from contamination as necessary.

containers, and utensils, hold, or store raw materials, process, rework, or reject, handled, and for manufacturing or other use that protects the food.

Measures shall be taken to ensure the inclusion of adequate material in the food with this requirement accomplished by using methods, electronic devices, or other suitable effective means.

Materials, and other ingredients, adulterated within the lot shall be destroyed or otherwise protected from contamination of other food. Food is capable of being contaminated, it shall be reprocessed by a method that has been found effective or it shall be found not to be the meaning of the food incorporated into the food.

Manufacturing steps including peeling, trimming, inspecting, mashing, shredding, extruding, whipping, defatting, and performed so as to prevent contamination. This requirement may be satisfied by providing adequate protection of food from contact with air, water, or other materials. Protection may be achieved by adequate cleaning and sanitizing of food-contact surfaces, and temperature control between each manufacturing step.

When required in the food, should be effective to the required time, and cooling the food or

passing it to subsequent manufacturing without delay. Thermophilic growth and contamination in blanchers should be minimized by the use of adequate operating temperatures and by periodic cleaning. Where the blanched food is washed prior to filling, water used shall be safe and of adequate sanitary quality.

(12) Batters, breadings, sauces, gravies, dressings, and other similar preparations shall be treated or maintained in such a manner that they are protected against contamination. Compliance with this requirement may be accomplished by any effective means, including one or more of the following:

(i) Using ingredients free of contamination.

(ii) Employing adequate heat processes where applicable.

(iii) Using adequate time and temperature controls.

(iv) Providing adequate physical protection of components from contaminants that may drip, drain, or be drawn into them.

(v) Cooling to an adequate temperature during manufacturing.

(vi) Disposing of batters at appropriate intervals to protect against the growth of microorganisms.

(13) Filling, assembling, packaging, and other operations shall be performed in such a way that the food is protected against contamination. Compliance with this requirement may be accomplished by any effective means, including:

(i) Use of a quality control operation in which the critical control points are identified and controlled during manufacturing.

(ii) Adequate cleaning and sanitizing of all food-contact surfaces and food containers.

(iii) Using materials for food containers and food packaging materials that are safe and suitable, as defined in § 130.3(d) of this chapter.

(iv) Providing physical protection from contamination, particularly airborne contamination.

(v) Using sanitary handling procedures.

(14) Food such as, but not limited to, dry mixes, nuts, intermediate moisture food, and dehydrated food, that relies on the control of a_w for preventing the

growth of undesirable microorganisms shall be processed to and maintained at a safe moisture level. Compliance with this requirement may be accomplished by any effective means, including employment of one or more of the following practices:

(i) Monitoring the a_w of food.

(ii) Controlling the soluble solids-water ratio in finished food.

(iii) Protecting finished food from moisture pickup, by use of a moisture barrier or by other means, so that the a_w of the food does not increase to an unsafe level.

(15) Food such as, but not limited to, acid and acidified food, that relies principally on the control of pH for preventing the growth of undesirable microorganisms shall be monitored and maintained at a pH of 4.6 or below. Compliance with this requirement may be accomplished by any effective means, including employment of one or more of the following practices:

(i) Monitoring the pH of raw materials, food in process, and finished food.

(ii) Controlling the amount of acid or acidified food added to low-acid food.

(16) When ice is used in contact with food, it shall be made from water that is safe and of adequate sanitary quality, and shall be used only if it has been manufactured in accordance with current good manufacturing practice as outlined in this part.

(17) Food-manufacturing areas and equipment used for manufacturing human food should not be used to manufacture nonhuman food-grade animal feed or inedible products, unless there is no reasonable possibility for the contamination of the human food.

[51 FR 24475, June 19, 1986, as amended at 65 FR 56479, Sept. 19, 2000]

§ 110.93 Warehousing and distribution.

Storage and transportation of finished food shall be under conditions that will protect food against physical, chemical, and microbial contamination as well as against deterioration of the food and the container.

Subpart F [Reserved]

product code, the date and time of container closure inspections, the measurements obtained, and all corrective actions taken. Records shall be signed or initialed by the container closure inspector and reviewed by management with sufficient frequency to ensure that the containers are hermetically sealed.

(d) Records shall be maintained to identify the initial distribution of the finished product to facilitate, when necessary, the segregation of specific food lots that may have become contaminated or otherwise rendered unfit for their intended use.

(e) Copies of all records provided for in this part, except those required under §113.83 establishing scheduled processes, shall be retained at the processing plant for a period of not less than 1 year from the date of manufacture, and at the processing plant or other reasonably accessible location for an additional 2 years. If, during the first year of the 3-year record-retention period, the processing plant is closed for a prolonged period between seasonal packs, the records may be transferred to some other reasonably accessible location at the end of the seasonal pack.

PART 114—ACIDIFIED FOODS

Subpart A—General Provisions

Sec.

114.3 Definitions.

114.5 Current good manufacturing practices.

114.10 Personnel.

Subparts B-D [Reserved]

Subpart E—Production and Process Controls

114.80 Processes and controls.

114.83 Establishing scheduled processes.

114.89 Deviations from scheduled procedures.

114.90 Methodology.

Subpart F—Records and Reports

114.100 Records.

AUTHORITY: 21 U.S.C. 342, 371, 374; 42 U.S.C. 264.

SOURCE: 44 FR 16235, Mar. 16, 1979, unless otherwise noted.

Subpart A—General Provisions

§ 114.3 Definitions.

For the purposes of this part, the following definitions apply.

(a) *Acid foods* means foods that have a natural pH of 4.6 or below.

(b) *Acidified foods* means low-acid foods to which acid(s) or acid food(s) are added; these foods include, but are not limited to, beans, cucumbers, cabbage, artichokes, cauliflower, puddings, peppers, tropical fruits, and fish, singly or in any combination. They have a water activity (a_w) greater than 0.85 and have a finished equilibrium pH of 4.6 or below. These foods may be called, or may purport to be, "pickles" or "pickled _____." Carbonated beverages, jams, jellies, preserves, acid foods (including such foods as standardized and nonstandardized food dressings and condiment sauces) that contain small amounts of low-acid food(s) and have a resultant finished equilibrium pH that does not significantly differ from that of the predominant acid or acid food, and foods that are stored, distributed, and retailed under refrigeration are excluded from the coverage of this part.

(c) *Lot* means the product produced during a period indicated by a specific code.

(d) *Low-acid foods* means any foods, other than alcoholic beverages, with a finished equilibrium pH greater than 4.6 and a water activity (a_w) greater than 0.85. Tomatoes and tomato products having a finished equilibrium pH less than 4.7 are not classed as low-acid foods.

(e) *Scheduled process* means the process selected by a processor as adequate for use under the conditions of manufacture for a food in achieving and maintaining a food that will not permit the growth of microorganisms having public health significance. It includes control of pH and other critical factors equivalent to the process established by a competent processing authority.

(f) *Shall* is used to state mandatory requirements.

(g) *Should* is used to state recommended or advisory procedures or to identify recommended equipment.

A—General Provisions**Definitions.**

Purposes of this part, the following definitions apply.

Foods means foods that have a pH of 4.6 or below.

Acidified foods means low-acid foods which contain one or more acid(s) or acid food(s). These foods include, but are not limited to, beans, cucumbers, cabbage, tomatoes, cauliflower, mushrooms, tropical fruits, and fish, in any combination. They have a water activity (a_w) greater than 0.85 and a finished equilibrium pH of 4.6 or below. These foods may be referred to as "pickles."

Carbonated beverages, jellies, preserves, acidified foods, and other nonstandardized food products (including such foods as standard nonstandardized food products and condiment sauces) that contain small amounts of low-acid ingredients and have a resultant finished pH that does not differ significantly from that of the predominant acid food, and foods that are distributed, and retailed, and their production is excluded from the scope of this part.

Acidified food means the product produced in the period indicated by a specific regulation.

Acid foods means any foods, including alcoholic beverages, with a finished equilibrium pH greater than 4.6 and a water activity (a_w) greater than 0.85. Tomatoes and tomato products with a finished equilibrium pH of 4.6 or below are not classed as low-acid foods.

Acidification process means the procedure by a processor as adequate under the conditions of manufacture to achieve and maintain a food in achieving and maintaining a food that will not permit the growth of microorganisms having health significance. It includes control of pH and other critical factors equivalent to the process established by a competent processing authority.

Authority is used to state mandatory requirements.

Advisory is used to state recommended procedures or to recommend equipment.

Food and Drug Administration, HHS**§ 114.80**

(h) *Water activity* (a_w) is a measure of the free moisture in a product and is the quotient of the water vapor pressure of the substance divided by the vapor pressure of pure water at the same temperature.

(41 FR 16235, Mar. 16, 1979, as amended at 61 FR 14245, Apr. 1, 1996)

§ 114.5 Current good manufacturing practice.

The criteria in §§ 114.10, 114.80, 114.83, 114.89, and 114.100, as well as the criteria in part 110 of this chapter, apply in determining whether an article of acidified food is adulterated (1) within the meaning of section 402(a)(3) of the act (21 U.S.C. 342(a)(3)) in that it has been manufactured under such conditions that it is unfit for food, or (2) within the meaning of section 402(a)(4) of the act (21 U.S.C. 342(a)(4)) in that it has been prepared, packed, or held under insanitary conditions whereby it may have become contaminated with filth, or whereby it may have been rendered injurious to health.

§ 114.10 Personnel.

All operators of processing and packaging systems shall be under the operating supervisions of a person who has attended a school approved by the Commissioner for giving instruction in food-handling techniques, food-protection principles, personal hygiene and plant sanitation practices, pH controls and critical factors in acidification, and who has been identified by that school as having satisfactorily completed the prescribed course of instruction. The Commissioner will consider students who have satisfactorily completed the required portions of the courses presented under § 108.35 and part 113 of this chapter before March 16, 1979, to be in compliance with the requirement of this section.

Subparts B-D [Reserved]**Subpart E—Production and Process Controls****§ 114.80 Processes and controls.**

(a) *Processing operations.* The manufacturer shall employ appropriate quality control procedures to ensure that

finished foods do not present a health hazard.

(1) Acidified foods shall be so manufactured, processed, and packaged that a finished equilibrium pH value of 4.6 or lower is achieved within the time designated in the scheduled process and maintained in all finished foods. Manufacturing shall be in accordance with the scheduled process. Acidified foods shall be thermally processed to an extent that is sufficient to destroy the vegetative cells of microorganisms of public health significance and those of nonhealth significance capable of reproducing in the food under the conditions in which the food is stored, distributed, retailed and held by the user. Permitted preservatives may be used to inhibit reproduction of microorganisms of nonhealth significance (in lieu of thermal processing).

(2) Sufficient control, including frequent testing and recording of results, shall be exercised so that the finished equilibrium pH values for acidified foods are not higher than 4.6. Measurement of acidity of foods in-process may be made by potentiometric methods, titratable acidity, or colorimetric methods. If the finished equilibrium pH of the food is above 4.0, the measurement of the finished equilibrium pH shall be by a potentiometric method, and the in-process measurements by titration or colorimetry shall be related to the finished equilibrium pH. If the finished equilibrium pH is 4.0 or below, then the measurement of acidity of the final product may be made by any suitable method. Special care should be taken when food ingredients have been subjected to lye, lime, or similar high pH materials.

(3) Procedures for acidification to attain acceptable equilibrium pH levels in the final food include, but are not limited to, the following:

(i) Blanching of the food ingredients in acidified aqueous solutions.

(ii) Immersion of the blanched food in acid solutions. Although immersion of food in an acid solution is a satisfactory method for acidification, care must be taken to ensure that the acid concentration is properly maintained.

(iii) Direct batch acidification, which can be achieved by adding a known

amount of an acid solution to a specified amount of food during acidification.

(iv) Direct addition of a predetermined amount of acid to individual containers during production. Liquid acids are generally more effective than solid or pelleted acids. Care must be taken to ensure that the proper amount of acid is added to each container.

(v) Addition of acid foods to low-acid foods in controlled proportions to conform to specific formulations.

(4) Testing and examinations of containers shall occur often enough to ensure that the container suitably protects the food from leakage or contamination.

(b) *Coding*. Each container or product shall be marked with an identifying code permanently visible to the naked eye. If the container does not permit the code to be embossed or inked, the label may be legibly perforated or otherwise marked, as long as the label is securely affixed to the product container. The required identification shall specify in code the establishment where the product was packed, the product contained therein, and the year, day, and period during which it was packed. The packing period code shall be changed often enough to enable ready identification of lots during their sale and distribution. Codes may be changed periodically on one of the following bases: intervals of 4 to 5 hours; personnel shift changes; or batches, as long as the containers constituting the batch do not represent those processed during more than one personnel shift.

§114.83 Establishing scheduled processes.

The scheduled process shall be established by a qualified person who has expert knowledge acquired through appropriate training and experience in the acidification and processing of acidified foods.

§114.89 Deviations from scheduled processes.

Whenever any process operation deviates from the scheduled process for any acidified food and/or the equilibrium pH of the finished product is higher

than 4.6, the commercial processor of the acidified food shall either: (a) Fully reprocess that portion of the food by a process established by a competent processing authority as adequate to ensure a safe product; (b) thermally process it as a low-acid food under part 113 of this chapter; or (c) set aside that portion of the food involved for further evaluation as to any potential public health significance. The evaluation shall be made by a competent processing authority and shall be in accordance with procedures recognized by competent processing authorities as being adequate to detect any potential hazard to public health. Unless the evaluation demonstrates that the food has undergone a process that has rendered it safe, the food set aside shall either be fully reprocessed to render it safe, or be destroyed. A record shall be made of the procedures used in the evaluation and the results. Either upon completion of full reprocessing and the attainment of a safe food, or after the determination that no significant potential for public health hazard exists, that portion of the food involved may be shipped in normal distribution. Otherwise, the portion of the food involved shall be destroyed.

§114.90 Methodology.

Methods that may be used to determine pH or acidity for acidified foods include, but are not limited to, the following:

(a) *Potentiometric method for the determination of pH*—(1) *Principles*. The term "pH" is used to designate the intensity or degree of acidity. The value of pH, the logarithm of the reciprocal of the hydrogen ion concentration in solution, is determined by measuring the difference in potential between two electrodes immersed in a sample solution. A suitable system consists of a potentiometer, a glass electrode, and a reference electrode. A precise pH determination can be made by making an electromotive force (emf) measurement of a standard buffer solution whose pH is known, and then comparing that measurement to an emf measurement of a sample of the solution to be tested.

(2) *Instruments*. The primary instrument for use in pH determination is the pH meter or potentiometer. For

most work, direct-reading potentiometer and available voltage instrument regulator meter-scale be checked operation. A expanded unit system is more precise.

(3) *Electrodes*. Equipped with a single electrode and single pH meter. Various for specific most common electrode is incorporated saturated

(i) *Care*. Electrodes saturated or otherwise damaged. For best results, soaked in deionized water for 24 hours before storing in water or standard solution. Rinsed with the standard water or next between lag in measuring electrodes, all of the electrode may be: electrode: side solution transferri chloric acid cycle showing solution. thorough with the: (ii) *Ten* results, a

commercial processor of food shall either: (a) Fully portion of the food by a method approved by a competent authority as adequate to ensure that the food is safe for consumption; (b) thermally process the food under part 113.5; or (c) set aside that portion of the food involved for further evaluation to any potential public health hazard. The evaluation shall be conducted by a competent processor and shall be in accordance with procedures recognized by the FDA. The processor shall be responsible for ensuring that the food is safe for consumption. A record shall be maintained of the results. Either upon reprocessing and the food is safe, or after the food is found to be safe, that no significant public health hazard exists, the food involved may be distributed. Other portions of the food involved shall be discarded.

Logistics.

may be used to determine the pH of acidified foods. This is not limited to, the following:

Standard method for the determination of pH.

(1) *Principles.* The term pH designates the intensity of acidity. The value of pH, is the reciprocal of the concentration in solution. It is determined by measuring the potential between two electrodes immersed in a sample solution. The system consists of a glass electrode, and a reference electrode. A precise pH determination is made by making an emf measurement of a solution whose pH is known, and then comparing that with an emf measurement of the solution to be tested. The primary instrument used for pH determination is a potentiometer. For

most work, an instrument with a direct-reading pH scale is necessary. Battery and line-operated instruments are available commercially. If the line voltage is unstable, line-operated instruments should be fitted with voltage regulators to eliminate drifting of meter-scale readings. Batteries should be checked frequently to ensure proper operation of battery operated instruments. An instrument using an expanded unit scale or a digital readout system is preferred since it allows more precise measurements.

(3) *Electrodes.* The typical pH meter is equipped with a glass membrane electrode and a reference electrode or a single probe combination electrode. Various types of electrodes designed for specific uses are available. The most commonly used reference electrode is the calomel electrode, which incorporates a salt bridge filled with saturated potassium chloride solution.

(i) *Care and use of electrodes.* Calomel electrodes should be kept filled with saturated potassium chloride solution or other solution specified by the manufacturer because they may become damaged if they are allowed to dry out. For best results, electrodes should be soaked in buffer solution, distilled or deionized water, or other liquid specified by the manufacturer for several hours before using and kept ready by storing with tips immersed in distilled water or in buffer solution used for standardization. Electrodes should be rinsed with water before immersing in the standard buffers and rinsed with water or the solution to be measured next between sample determinations. A lag in meter response may indicate aging effects or fouling of the electrodes, and cleaning and rejuvenation of the electrodes may be necessary and may be accomplished by placing the electrodes in 0.1 molar sodium hydroxide solution for 1 minute and then transferring them to 0.1 molar hydrochloric acid solution for 1 minute. The cycle should be repeated two times, ending with the electrodes in the acid solution. The electrodes should then be thoroughly rinsed with water and blotted with soft tissue before proceeding with the standardization.

(ii) *Temperature.* To obtain accurate results, a uniform temperature should

be maintained for the electrodes, the standard buffer solutions, and the samples. Tests should be made at a temperature between 20° and 30 °C, the optimum being 25 °C. Any temperature determinations made without meter compensation may affect pH values. An automatic temperature compensator may be used.

(iii) *Accuracy.* The accuracy of most pH meters is stated to be approximately 0.1 pH unit, and reproducibility is usually ± 0.05 pH unit or less. Some meters permit the expansion of any pH unit range to cover the entire scale and have an accuracy of approximately ± 0.01 pH unit and a reproducibility of ± 0.005 pH units.

(4) *General procedure for determining pH.* When operating an instrument, the operator should use the manufacturer's instructions and should observe the following techniques for pH determinations:

(i) Switch the instrument on and allow the electronic components to warm up and stabilize before proceeding.

(ii) Standardize the instrument and electrodes with commercially prepared standard 4.0 pH buffer or with freshly prepared 0.05 molar potassium acid phthalate buffer solution prepared as outlined in "Official Methods of Analysis of the Association of Official Analytical Chemists" (AOAC), 13th Ed. (1980), section 50.007(c), under "Buffer Solutions for Calibration of pH Equipment—Official Final Action," which is incorporated by reference. Copies may be obtained from the Association of Official Analytical Chemists International, 481 North Frederick Ave., suite 500, Gaithersburg, MD 20877-2504, or may be examined at the National Archives and Records Administration (NARA). For information on the availability of this material at NARA, call 202-741-6030, or go to: http://www.archives.gov/federal_register/code_of_federal_regulations/ibr_locations.html. Note the temperature of the buffer solution and set the temperature compensator control at the observed temperature (room temperature is near 25 °C).

(iii) Rinse the electrodes with water and blot, but do not wipe, with soft tissue.

(iv) Immerse the tips in the buffer solution and take the pH reading, allowing about 1 minute for the meter to stabilize. Adjust the standardization control so that the meter reading corresponds to the pH of the known buffer (for example, 4.0) for the temperature observed. Rinse the electrodes with water and blot with soft tissue. Repeat procedure with fresh portions of buffer solution until the instrument remains in balance on two successive trials. To check the operation of the pH meter, check the pH reading using another standard buffer such as one having a pH of 7.0, or check it with freshly prepared 0.025 molar phosphate solution prepared as outlined in the AOAC, 13th Ed. (1980), section 50.007(e), which is incorporated by reference. The availability of this incorporation by reference is given in paragraph (a)(4)(ii) of this section. Expanded scale pH meters may be checked with pH 3.0 or pH 5.0 standard buffers. Buffers and instruments can be further checked by comparison with values obtained with a second properly standardized instrument.

(v) Indicating electrodes may be checked for proper operation by first using an acid buffer and then a base buffer. First standardize the electrodes using a pH 4.0 buffer at or near 25 °C. Standardization control should be adjusted so that the meter reads exactly 4.0. Electrodes should be rinsed with water, then blotted and immersed in a pH 9.18 borax buffer prepared as outlined in the AOAC, 13th Ed. (1980), section 50.007(f), which is incorporated by reference. The availability of this incorporation by reference is given in paragraph (a)(4)(ii) of this section. The pH reading should be within ± 0.3 units of the 9.18 value.

(vi) The pH meter can be tested for proper operation by shorting the glass and reference electrode inputs, thereby reducing the voltage to zero. In some meters this shorting is done by switching the instrument to standby, and in other instruments by use of a shorting strap. With the instrument shorted out, standardization control should be turned from one extreme to another. This operation should produce a deflection greater than ± 1.5 pH unit from center scale.

(5) *Determining pH on samples.* (i) Adjust the temperature of the sample to room temperature (25 °C), and set the temperature compensator control to the observed temperature. With some expanded scale instruments, the sample temperature must be the same as the temperature of the buffer solution used for the standardization.

(ii) Rinse and blot the electrodes. Immerse the electrodes in the sample and take the pH reading, allowing 1 minute for the meter to stabilize. Rinse and blot the electrodes and repeat on a fresh portion of sample. Oil and grease from the samples may coat the electrodes; therefore, it is advisable to clean and standardize the instrument frequently. When oily samples cause fouling problems, it may become necessary to rinse the electrodes with ethyl ether.

(iii) Determine two pH values on the well-mixed sample. These readings should agree with one another to indicate that the sample is homogeneous. Report values to the nearest 0.05 pH unit.

(6) *Preparation of samples.* Some food products may consist of a mixture of liquid and solid components that differ in acidity. Other food products may be semisolid in character. The following are examples of preparation procedures for pH testing for each of these categories:

(i) *Liquid and solid component mixtures.* Drain the contents of the container for 2 minutes on a U.S. standard No. 8 sieve (preferably stainless steel) inclined at a 17- to 20-degree angle. Record weight of the liquid and solid portions and retain each portion separately.

(a) If the liquid contains sufficient oil to cause electrode fouling, separate the layers with a separatory funnel and retain the aqueous layer. The oil layer may be discarded. Adjust the temperature of the aqueous layer to 25 °C and determine its pH.

(b) Remove the drained solids from the sieve, blend to a uniform paste, adjust the temperature of the paste to 25 °C and determine its pH.

(c) Mix aliquots of solid and liquid fractions in the same ratio as found in the original container and blend to a

uniform consistency. Adjust the temperature of the sample to room temperature (25 °C), and set the temperature compensator control to the observed temperature. With some expanded scale instruments, the sample temperature must be the same as the temperature of the buffer solution used for the standardization.

(ii) *Marinated solids.* Remove the oil from the sample. Blend the solid in a blender to a uniform consistency; it may be necessary to add a small amount of water to some samples. A small amount of water will not affect the pH of food products, but excessive water will dilute the sample. No more than 100 grams of distilled water should be added per 100 grams of product. Immerse the electrodes in the prepared paste after the temperature has reached 25 °C.

(iii) *Semisolid products.* A semisolid product, such as a potato salad, may be determined by determining the pH of a paste. If more fluidity is required, add 20 milliliters of distilled water to 100 grams of product and adjust the temperature to 25 °C and determine its pH.

(iv) *Special products.* For special product mixtures, such as a product mixture, pour off the liquid and retain the product. Determine the pH of the product. If more fluidity is required, add 20 milliliters of distilled water to 100 grams of product and adjust the temperature to 25 °C and determine its pH.

(7) *Process pH.* Determine the pH of sample portions of the product at termination.

(i) For process products, determine the pH of the product at termination. Immerse the electrodes in the liquid and determine the pH.

(ii) Drain solid portions from the liquid and blend to a uniform paste. Adjust the temperature of the paste to 25 °C and determine its pH.

(iii) If enough sample is available to make representative aliquots, mix aliquots of solid and liquid materials to a uniform consistency and determine the pH.

nining pH on samples. (i) Adjust the temperature of the sample to 25 °C, and set the compensator control to the same temperature. With some scale instruments, the same temperature must be the same as the temperature of the buffer solution for standardization.

and blot the electrodes. Immerse the electrodes in the sample and take a reading, allowing 1 minute for the reading to stabilize. Rinse the electrodes and repeat on another sample. Oil and grease on the electrodes may coat the electrodes and repeat on another sample. Therefore, it is advisable to standardize the instrument before use. When oily samples cause problems, it may become necessary to rinse the electrodes with distilled water.

Determine two pH values on the sample. These readings should be within one another to indicate the sample is homogeneous. Round the pH to the nearest 0.05 pH.

Preparation of samples. Some food samples may consist of a mixture of solid components that differ from other food products may be of a different character. The following are procedures for preparation procedures for each of these categories:

Liquid and solid component mixtures. Blend the contents of the container in a U.S. standard (preferably stainless steel) container at a 17- to 20-degree angle. Separate the liquid and solid portions and retain each portion separately.

If the liquid contains sufficient solids to cause electrode fouling, separate the liquid from the solid with a separatory funnel and remove the aqueous layer. The oil layer is discarded. Adjust the temperature of the liquid to 25 °C and determine its pH.

Remove the drained solids from the container and blend to a uniform paste, adjust the temperature of the paste to 25 °C and determine its pH.

Take aliquots of solid and liquid in the same ratio as found in the container and blend to a

uniform consistency. Adjust the temperature of the blend to 25 °C and determine the equilibrated pH. Alternatively, blend the entire contents of the container to a uniform paste, adjust the temperature of the paste to 25 °C, and determine the equilibrated pH.

(ii) *Marinated oil products.* Separate the oil from the solid product. Blend the solid in a blender to a paste consistency; it may become necessary to add a small amount of distilled water to some samples to facilitate the blending. A small amount of added water will not alter the pH of most food products, but caution must be exercised concerning poorly buffered foods. No more than 20 milliliters of distilled water should be added to each 100 grams of product. Determine the pH by immersing electrodes in the prepared paste after adjusting the temperature to 25 °C.

(iii) *Semisolid products.* Food products of a semisolid consistency, such as puddings, potato salad, etc., may be blended to a paste consistency, and the pH may be determined on the prepared paste. If more fluidity is required, 10 to 20 milliliters of distilled water may be added to 100 grams of product. Adjust the temperature of the prepared paste to 25 °C and determine its pH.

(iv) *Special product mixtures.* For special product mixtures such as antipasto, pour off the oil, blend the remaining product to a paste, and determine the pH of the blended paste. If more fluidity is required, add 10 to 20 milliliters of distilled water to each 100 grams of product and blend. Adjust the temperature of the prepared paste to 25 °C and determine its pH.

(7) *Process pH determination.* Obtain sample portions of material for pH determination.

(i) For process liquids, adjust the temperature of the liquid to 25 °C and determine the pH by immersing the electrodes in the liquid.

(ii) Drain solid materials on a sieve and blend to a workable paste. Adjust the temperature of the prepared paste to 25 °C and determine its pH.

(iii) If enough solid materials are available to make a paste, blend representative aliquots of liquid and solid materials to a workable paste. Adjust the temperature of the prepared paste

to 25 °C and determine the equilibrated pH. Alternatively, blend the entire contents of the container to a uniform paste, adjust the temperature of the paste to 25 °C, and determine the equilibrated pH.

(b) *Colorimetric methods for the determination of pH.* This method may be used in lieu of the potentiometric method if the pH is 4.0 or lower.

(1) *Principle.* The colorimetric method for pH involves the use of indicator dyes in solutions that gradually change color over limited pH ranges. An indicator that has the greatest color change at approximately the pH of the sample being tested is selected. The pH is determined by the color of the indicator when exposed to the sample under test.

(2) *Indicator solutions.* Most indicator solutions are prepared as a 0.04 percent solution of the indicator dye in alcohol. In testing, a few drops of indicator solution are added to 10-milliliter portions of the sample solution. Colors should be compared using a bright background. Approximate determinations can be made on white porcelain spot plates, the test colors being compared thereon with a set of color standards. More accurate colorimetric tests can be made using a comparator block fitted with sets of tubes of standard indicator solutions of known pH.

(3) *Indicator paper.* A paper tape treated with indicator dye is dipped into the sample solution. Depending upon the pH of the solution, the tape will change color and an approximate pH can be determined by comparison with a standard color chart.

(c) *Titratable acidity.* Acceptable methods for determining titratable acidity are described in the AOAC, 13th Ed. (1980), section 22.060, under "Titratable Acidity—Official Final Action," for "Indicator Method," and section 22.061 for "Glass Electrode Method—Official Final Action," which is incorporated by reference. The availability of this incorporation by reference is given in paragraph (a)(4)(ii) of this section. The procedure for preparing and standardizing the sodium hydroxide solution is described in the AOAC, 13th Ed. (1980), sections 50.032-50.035, under "Sodium Hydroxide—Official Final Action" by the "Standard

Potassium Hydroxide Phthalate Method," which is also incorporated by reference and available as set forth in paragraph (a)(4)(ii) of this section.

[44 FR 16235, Mar. 16, 1979, as amended at 47 FR 11822, Mar. 19, 1982; 49 FR 5609, Feb. 14, 1984; 54 FR 24892, June 12, 1989; 63 FR 14035, Mar. 24, 1998]

Subpart F—Records and Reports

§ 114.100 Records.

(a) Records shall be maintained of examinations of raw materials, packaging materials, and finished products, and of suppliers' guarantees or certifications that verify compliance with Food and Drug Administration regulations and guidance documents or action levels.

(b) Processing and production records showing adherence to scheduled processes, including records of pH measurements and other critical factors intended to ensure a safe product, shall be maintained and shall contain sufficient additional information such as product code, date, container size, and product, to permit a public health hazard evaluation of the processes applied to each lot, batch, or other portion of production.

(c) All departures from scheduled processes having a possible bearing on public health or the safety of the food shall be noted and the affected portion of the product identified; these departures shall be recorded and made the subject of a separate file (or log identifying the appropriate data) delineating them, the action taken to rectify them, and the disposition of the portion of the product involved.

(d) Records shall be maintained identifying initial distribution of the finished product to facilitate, when necessary, the segregation of specific food lots that may have become contaminated or otherwise unfit for their intended use.

(e) Copies of all records provided for in paragraphs (b), (c), and (d) of this section shall be retained at the processing plant or other reasonably accessible location for a period of 3 years from the date of manufacture.

[44 FR 16235, Mar. 16, 1979, as amended at 65 FR 56479, Sept. 19, 2000]

PART 115—SHELL EGGS

AUTHORITY: 21 U.S.C. 342, 371; 42 U.S.C. 243, 264, 271.

§ 115.50 Refrigeration of shell eggs held for retail distribution.

(a) For purposes of this section a "retail establishment" is an operation that stores, prepares, packages, serves, vends, or otherwise provides food for human consumption directly to consumers.

(b) Except as provided in paragraph (c) of this section, all shell eggs, whether in intrastate or interstate commerce, held for retail distribution:

(1) Shall promptly be placed under refrigeration as specified in paragraph (b)(2) of this section upon receipt at a retail establishment, except that, when short delays are unavoidable, the eggs shall be placed under refrigeration, as soon as reasonably possible; and

(2) Shall be stored and displayed under refrigeration at an ambient temperature not greater than 7.2 °C (45 °F) while held at a retail establishment.

(c) Shell eggs that have been specifically processed to destroy all viable *Salmonella* shall be exempt from the requirements of paragraph (b) of this section.

(d) Under sections 311 and 361 of the Public Health Service Act (PHS Act), any State or locality that is willing and able to assist the agency in the enforcement of paragraph (b) of this section, and is authorized to inspect or regulate retail establishments, may, in its own jurisdiction, enforce paragraph (b) of this section through inspections under paragraph (f) of this section and through administrative enforcement remedies identified in paragraph (e) of this section until FDA notifies the State or locality in writing that such assistance is no longer needed. When providing assistance under paragraph (e) of this section, a State or locality may follow the hearing procedures set out in paragraphs (e)(2)(iii) through (e)(2)(iv) of this section, substituting, where necessary, appropriate State or local officials for designated FDA officials or may utilize State or local hearing procedures if such procedures satisfy due process.